

9. Quality assurance through internal monitoring

From the inspection of incoming raw materials, monitoring of extruded profile properties to the check on dimensional accuracy and surface finish, REHAU window and door profiles are subjected to the following quality assurance measures:

a) Incoming inspection

Samples are taken from all deliveries of raw materials and subjected to chemical and physical tests to defined criteria. Any materials failing the test are returned to the supplier.

b) Mixing process monitoring

Large batches – produced in a closed system employing appropriate monitoring functions, automatic weighing, distribution and conveyance – guarantee consistent compound quality.

c) Dimensional accuracy

and profile surface quality monitoring

- Profile dimensions
- Surface quality and flatness
- Consistency of colour
- Axial profile distortion and twisting

d) Monitoring of profile physical/chemical properties

- Dimensional variation and behaviour after exposure to heat
- Impact resistance at low temperatures
- Notched impact strength
- Methylene chloride test
- Welded corner strength
- Colour fastness and resistance to weathering

10. Quality assurance through independent monitoring

REHAU S717 patio door profiles are subject to international independent monitoring in accordance with the UEATC directives.

11. System features

- a) Frame and sash profiles are designed for ease of fabrication and installation. There is minimal preparation to install fittings.
- b) The frame and sashes are fully welded. Ideal for efficient volume production.
- c) Sashes can be installed on site.
- d) Concealed frame and sash drainage.
- e) Easy-to-fit brush seals.
- f) Simple on-site installation. Neat finishing profiles clip onto the frame upstands.
- g) Accommodates glazing units in thicknesses up to 28mm (24mm thermally efficient, 28mm acoustically efficient).
- h) Robust, easily fitted rollers adjustable in height.
- i) Internally glazed. Glazing beads permit simple glazing in the workshop or on site.
- j) A clever injection moulding is used as the frame seal and anti lift device.
- k) A dedicated patio door stop provides a neat solution to an old problem. Conventional stops can be unsightly and are prone to falling off but this ingenious design actually caps off the frame detail and is held captive for a long working life.
- l) Neat range of finishing profiles. Frame infill is made from PVCu and snap fits for speed and cleanliness of appearance.
- m) The 70mm (very slim) outer frame is fully compatible with the REHAU S710 range of ancillary profiles. The frame can be coupled with REHAU Tritec or S706 (60 or 70mm deep) frame profiles, thus the S717 patio door is ideal for use in conservatories or porches.



REHAU S717 PATIO DOOR SYSTEM DESCRIPTION

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S717 PATIO DOOR SYSTEM DESCRIPTION

1. Construction

The outer frame is 70mm deep and is used on all four sides. It is welded at the corners. To assist the smoother running of the sashes and to ensure long-term performance, an aluminium running track is clipped onto the bottom profile.

The sashes are 47mm deep. The same sash profile is used on all four sides and the corners are welded.

A choice of 3 glazing beads, permits the use of glazing units from 20 to 28mm thick.

All four sides of the sash are fitted with twin brushpile seals to provide weather performance.

The sash interlock seal is formed by means of 2 brushpile seals. A special injection moulded infill, accommodates brushpile and is inserted into the head and sill frame profile at the interlock. This serves as a barrier to protect from driving rain and prevents sashes from being lifted off the running track.

The frame rebate slopes outwards to assist drainage, which is achieved through routed drainage slots.

2. Colour

- White, no.159
- Mahogany, Renolite foil ref: 206 5021-167.

3. Opening styles

- Double sash doors
- Triple-sash doors
- Quadruple sash doors, only for specific applications because of reduced performance.

4. Maximum sizes

The ratio between height and width of the sash shall not exceed 2.5:1 in order to guarantee proper sliding function.

Max sash size:
1200mm wide x 2100mm height

Min sash size:
600mm wide x 1500mm height

Ratio sash height to width: 2.5:1

Maximum weight per sash 80kg.

5. Fittings

A choice of commercially available rollers are available. They run on bearings and can be adjusted in height.

The sash profile has a groove which allows easy fitting of espagnolette type locks. Locks are available from a variety of fitting suppliers (e.g GU, Ferco, Siegenia and Aubi).

6. Material

REHAU window profiles are made from high-impact, weather-resistant RAU-PVC 1406 to DIN 7748, an unplasticised, modified polyvinyl chloride that has been practice-proven in window construction for over thirty years.

7. Thermal insulation

The thermal insulation performance of a S717 patio door depends on the type of glazing, the frame material and also on the size of the patio door itself.

Material:

RAU-PVC 1406, thermal conductivity 0.14 W/m2K.

8. Sound insulation

The sound insulation performance of a door is dependant on the type of glazing.

